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(54) Title: **ROLLING FORMULATION**

(57) Abstract: A water-soluble rolling oil composition comprises 15 to 70 % by weight of a partial polyol ester which has a hydroxyl value of between 20 and 50 mg KOH/g and a level of polyunsaturation of between 0.01 to 8 % by weight. The water-soluble rolling oil composition has been specifically designed for use in cold steel rolling applications. The use of the specific partial polyol ester in the rolling oil formulation meets the "plate-out" requirements of the mill owners and the requirements for steel sheet surface quality without any corresponding detriment to any of the other water-soluble rolling oil composition requirements, in particular lubricity.



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